

ITEM #	QTY	PART #	PART TITLE					
-1	1	RBW6510G04631-6F-1	REACTION WELDMENT ASSEMBLY	D	D	D	D	D
-5	1	RBW6510G04631-6F-5	SPACER					
-6	2	RBW6510G04631-6F-6	BRACKET					
-7	2	RBW6510G04631-6F-7	BRACKET PROTECTOR					
-8	2	RBW6510G04631-6F-8	BRACKET PIN					
9	2	McMaster#3896T31 OR EQUIV.	ALUMINUM WIRE ROPE COMPRESSION SLEEVE 1/16" DIA. X 3/8" LG.					
10	1	McMaster#90272A423 OR EQUIV.	ZINC PLATED STEEL PAN HEAD PHILLIPS SCREW #10-32 X 3/16" LG.					
11	2	McMaster#90273A192 OR EQUIV.	ZINC PLATED STEEL PHILLIPS FLAT HEAD SCREW #8-32 X 3/8" LG. X 82° CSK.					
12	3	McMaster#90273A193 OR EQUIV.	ZINC PLATED STEEL PHILLIPS FLAT HEAD SCREW #8-32 X 7/16" LG. X 82° CSK.					
13	1	McMaster#90905A655 OR EQUIV.	316 SS SPLIT RING 15/16" ID. X 1-1/16" OD. X 1/8" THK.					
14	1	McMaster#94505A115 OR EQUIV.	17-4 PH SS T-HANDLE QUICK RELEASE PIN 3/16" DIA. X 1-1/2" USABLE LG.					
15	1	McMaster#97840A460 OR EQUIV.	18-8 SS TAB FOR WIRE ROPE LANYARD 1.40" LG. X 1/2" WIDTH. X 1/16" THK.					
16	2	McMaster#98410A110 OR EQUIV.	BERYLLIUM COPPER RETAINING RING FOR 3/16" OD. X 0.168" ID. X 0.015" THK.					
17	1	CARR-LANE#CL-2-C	NYLON COATED STEEL LANYARD 1/16" DIA.					

RBW6510G04631-6F REACTION ASSEMBLY

SECTION A-A

SECTION B-B
(ROTATED 18° CW)

NOTES:

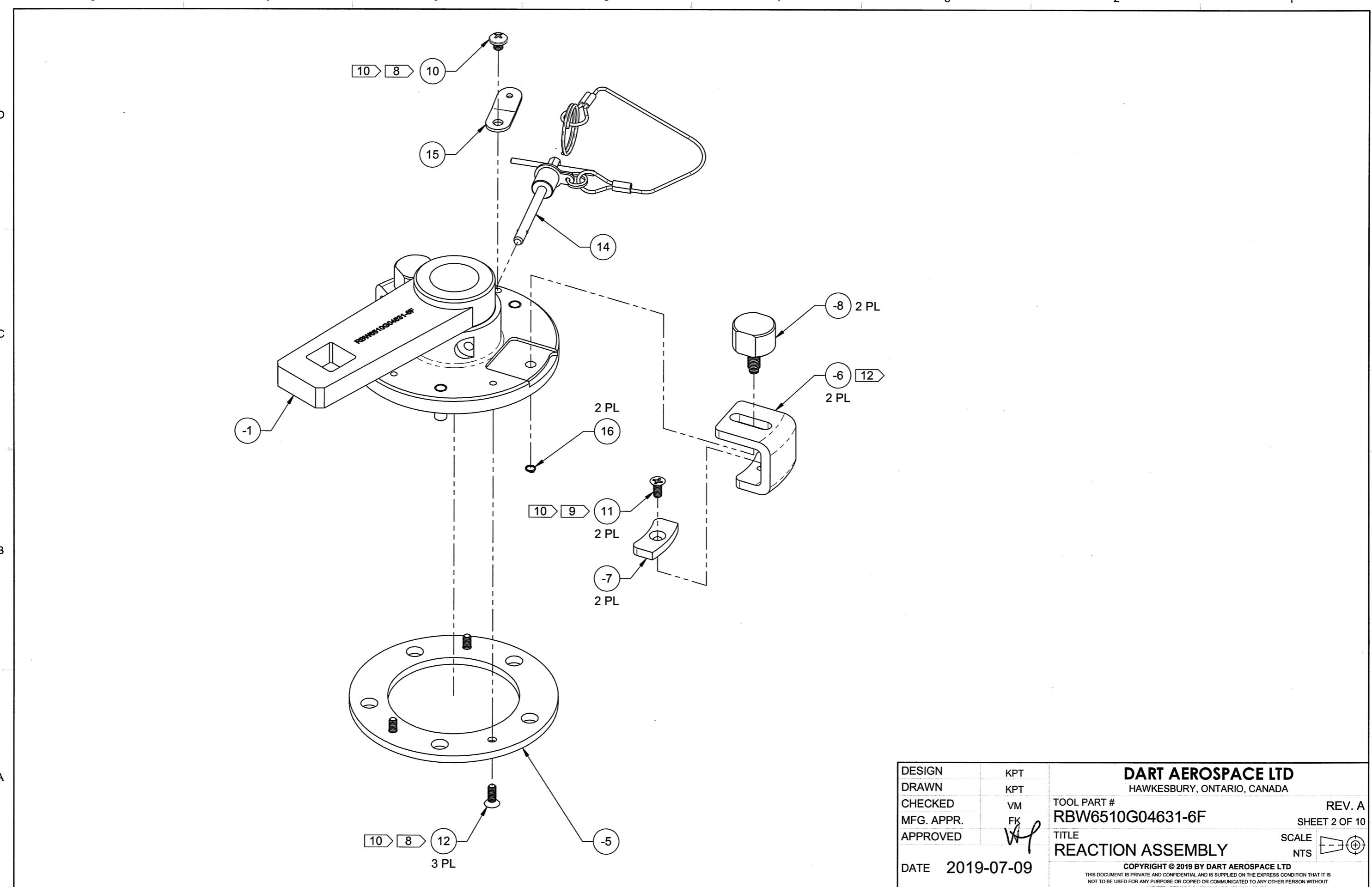
- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEMS 10 AND 12 THEN ASSEMBLE WITH ITEM -1, AND REMOVE EXCESS
- 9) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 11 THEN ASSEMBLE WITH ITEM -6, AND REMOVE EXCESS
- 10) INSTALL ITEMS 10, 11, AND 12 HAND TIGHT
- 11) ASSEMBLED LANYARD LENGTH MUST BE 6" +/- 1", LANYARD MUST MOVE FREELY WHEN INSTALLING/REMOVING ITEM 14
- 12) ITEM -6 MUST SLIDE FREELY WHEN ITEM -8 IS LOOSENED
- 13) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

A	NEW ISSUE	19-807	KPT
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	REV. A	
MFG. APPR.	FK	SHEET 1 OF 10	
APPROVED	WP	SCALE	
DATE 2019-07-09		NTS	

TOOL PART #
RBW6510G04631-6F

TITLE
REACTION ASSEMBLY

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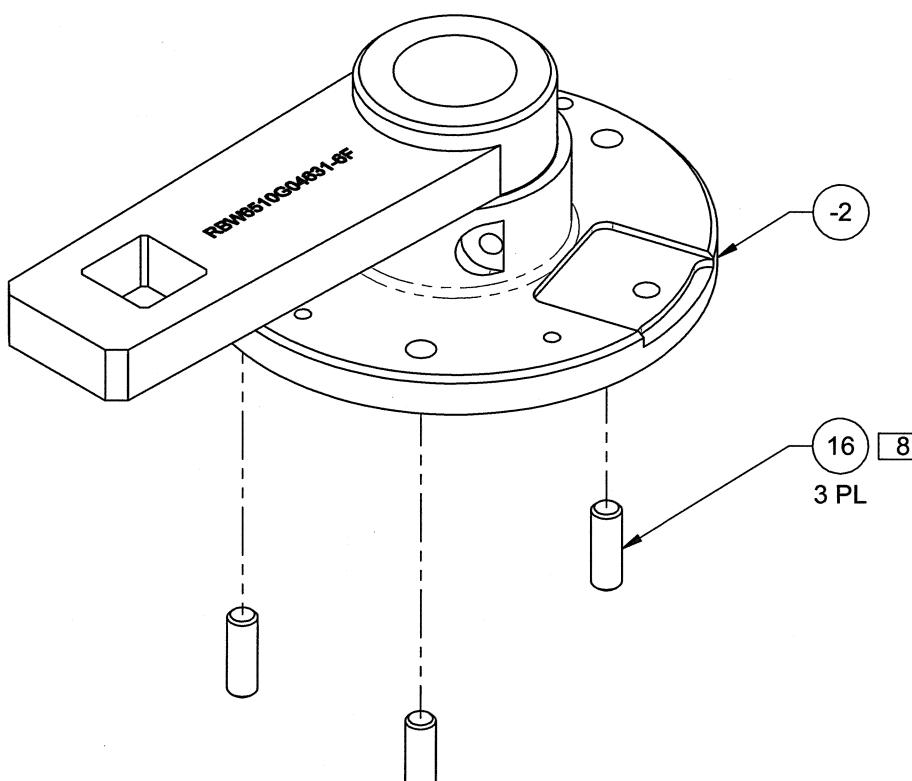
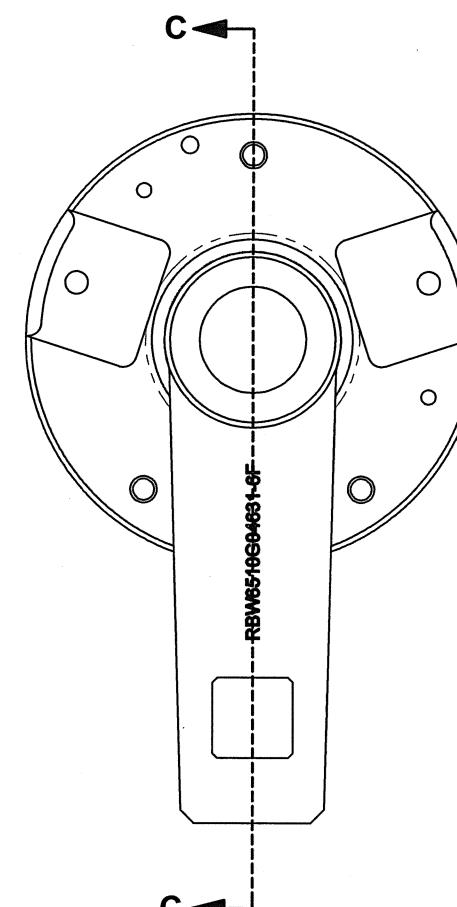
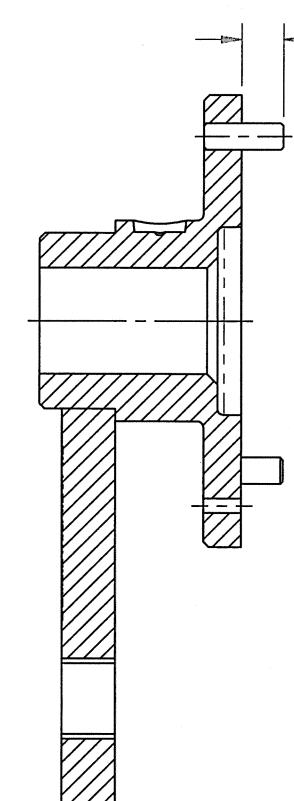


DESIGN	KPT	DART AEROSPACE LTD			
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA			
CHECKED	VM				
MFG. APPR.	FK				
APPROVED	[Signature]				
DATE	2019-07-09				
TOOL PART #		RBW6510G04631-6F	REV. A		
TITLE		REACTION ASSEMBLY			
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ITEM #	QTY	PART #	PART TITLE	
-2	1	RBW6510G04631-6F-2	REACTION WELDMENT	
16	3	McMaster#98381A328 OR EQUIV.	BLACK OXIDE STEEL DOWEL PIN 1/4" DIA. X 3/4" LG.	

8 7 6 5 4 3 2 1

D C B A D C B A

RBW6510G04631-6F-1 REACTION WELDMENT ASSEMBLY

NOTES:

1) MATERIAL: N/A
 2) HEAT TREAT: N/A
 3) FINISH: N/A
 4) TOLERANCES: X.X = $+\/- 0.1"$ / $+\/- 1^\circ$
 $X.XX = $+\/- 0.01"$ / $+\/- 0.5^\circ$$
 $X.XXX = $+\/- 0.005"$ / $+\/- 0.1^\circ$$
 $X.XXXX = $+\/- 0.0005"$ / $+\/- 0.05^\circ$$
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+\/- 0.005"$
 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 6) IDENTIFICATION: N/A
 7) ASSEMBLE AS SHOWN
 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
 THEN PRESS FIT ITEM 16 FLUSH WITH ITEM -2, AND REMOVE EXCESS

DESIGN	KPT
DRAWN	KPT
CHECKED	VM
MFG. APPR.	FK
APPROVED	<i>WJ</i>

DATE 2019-07-09

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

TOOL PART # **RBW6510G04631-6F**

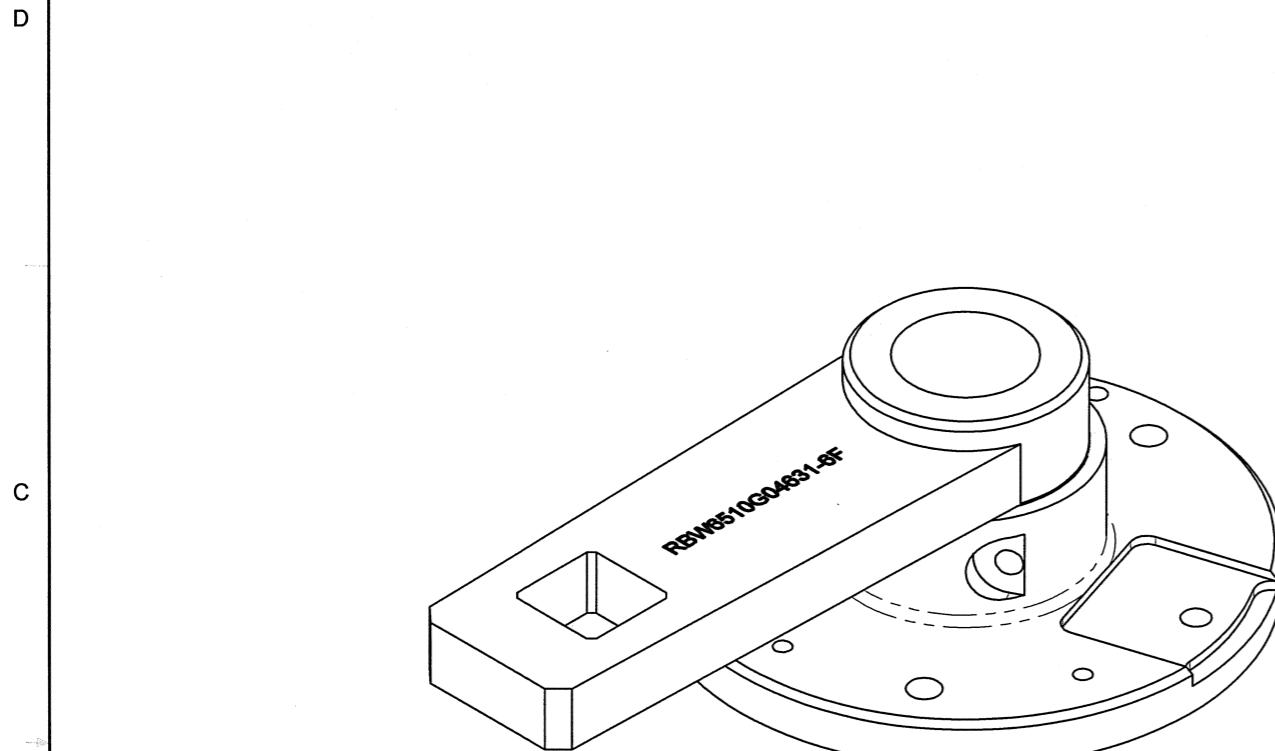
REV. A
 SHEET 3 OF 10

SCALE NTS 

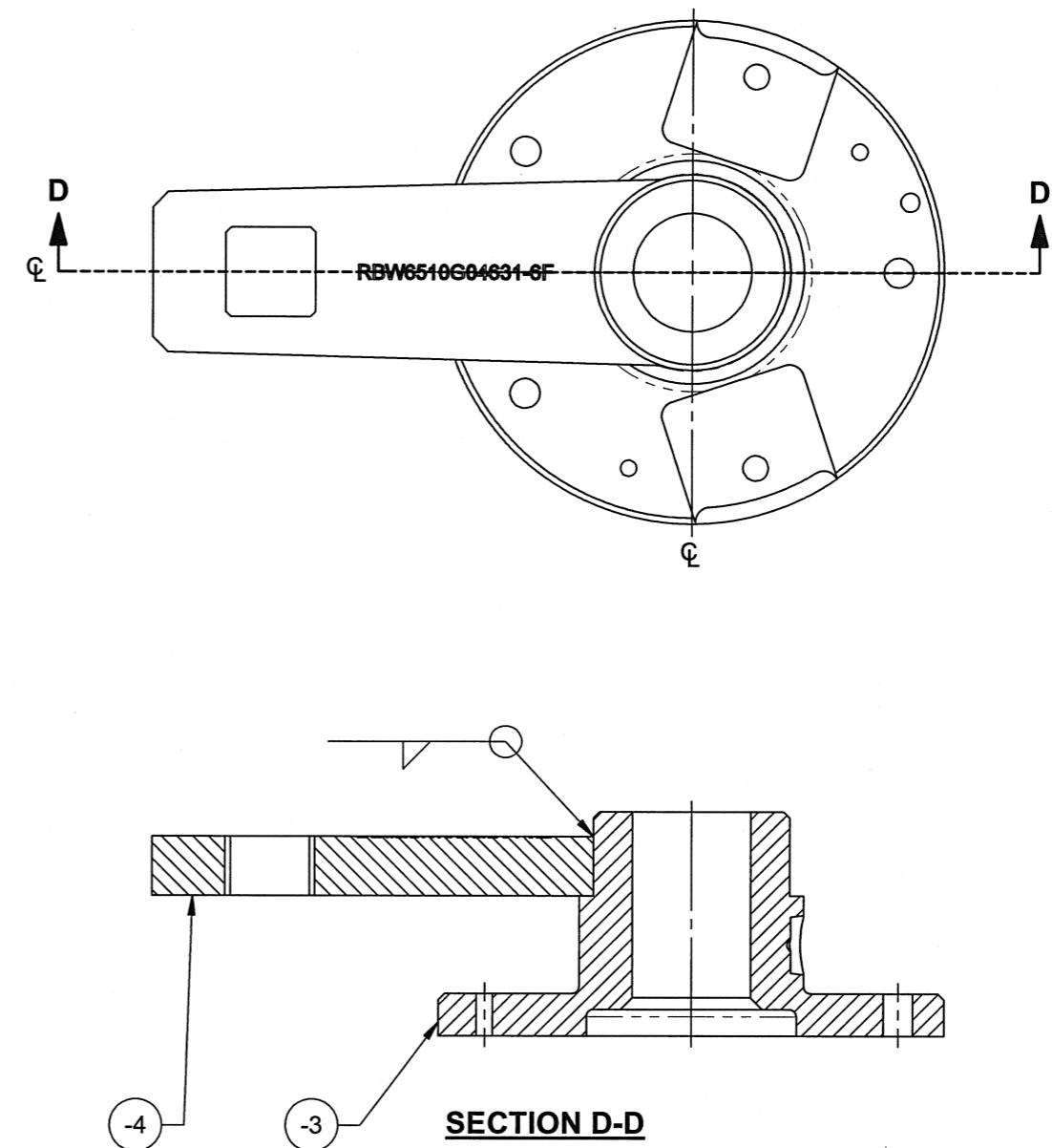
TITLE
REACTION ASSEMBLY

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ITEM #	QTY	PART #	PART TITLE
-3	1	RBW6510G04631-6F-3	REACTION
-4	1	RBW6510G04631-6F-4	HANDLE



RBW6510G04631-6F-2 REACTION WELDMENT

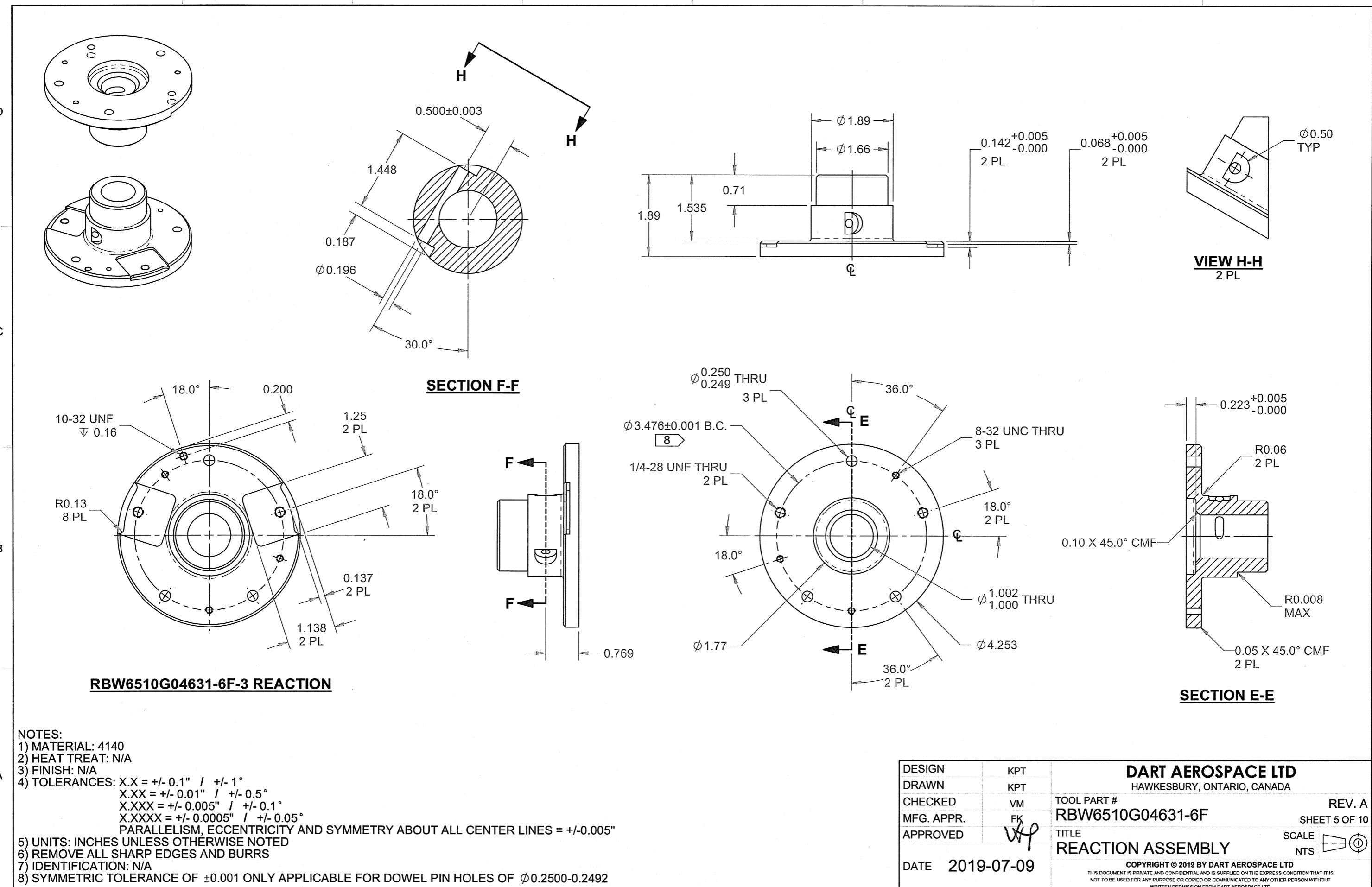


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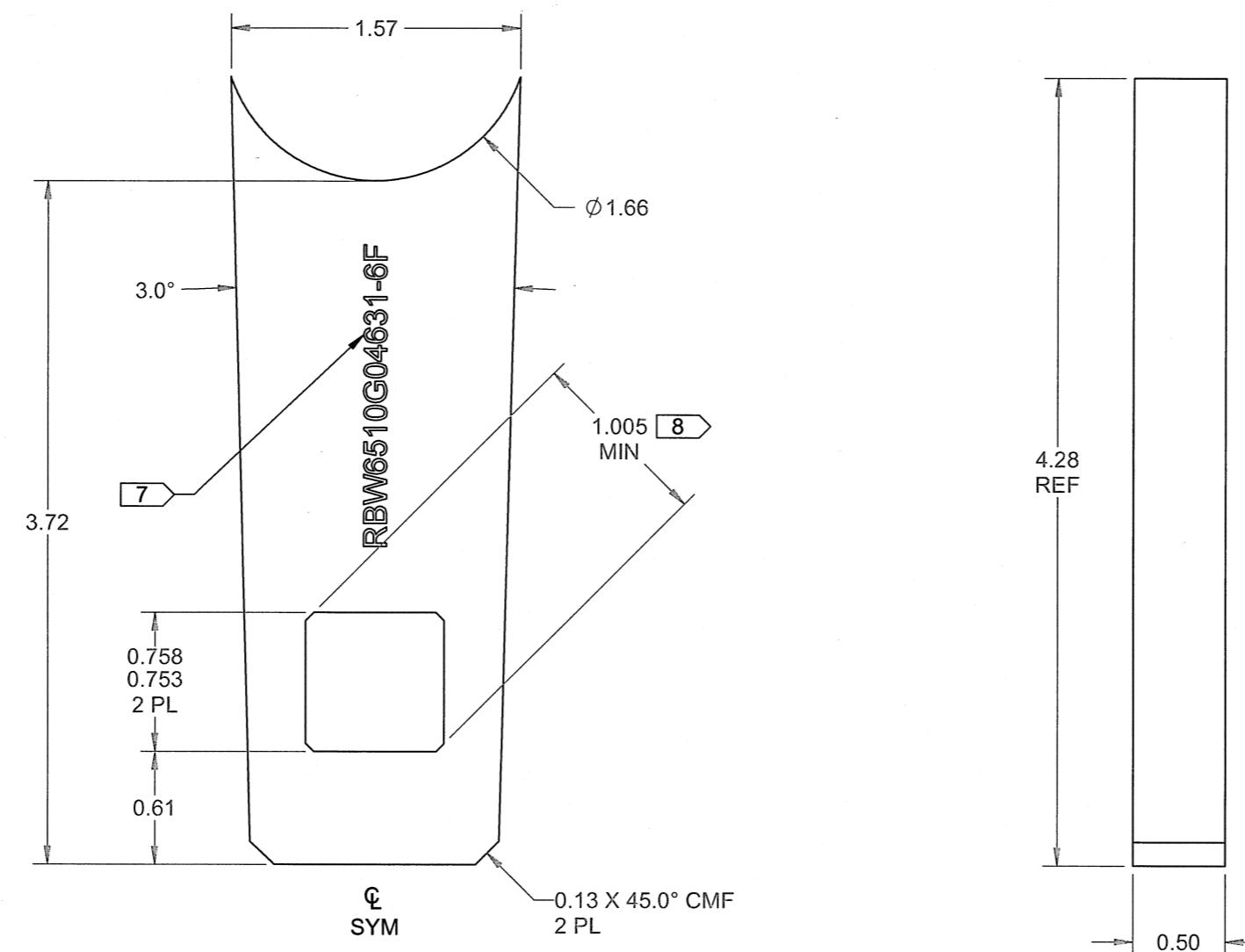
- 1) MATERIAL: N/A
- 2) HEAT TREAT: 36-40 RC
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL WELD SPATTERS
- 7) IDENTIFICATION: N/A
- 8) ASSEMBLE AS SHOWN

DESIGN DRAWN	KPT KPT	DART AEROSPACE LTD
CHECKED	VM	HAWKESBURY, ONTARIO, CANADA
MFG. APPR.	FK	REV. A
APPROVED	WJ	TOOL PART # RBW6510G04631-6F
DATE 2019-07-09		SHEET 4 OF 10
TITLE REACTION ASSEMBLY		SCALE NTS

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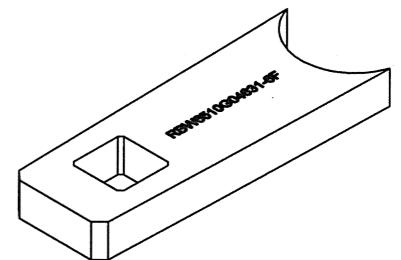


RBW6510G04631-6F-4 HANDLE

NOTES:

- 1) MATERIAL: 4140
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RBW6510G04631-6F", AS SHOWN
- 8) BROACH CORNERS CAN BE RELIEVED WITH 1/16" DRILL DIA. IF NECESSARY

DESIGN DRAWN	KPT KPT	DART AEROSPACE LTD	
CHECKED	VM	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	FK	TOOL PART #	RBW6510G04631-6F
APPROVED	<i>WJ</i>	TITLE	REACTION ASSEMBLY
DATE 2019-07-09		REV. A	SHEET 6 OF 10
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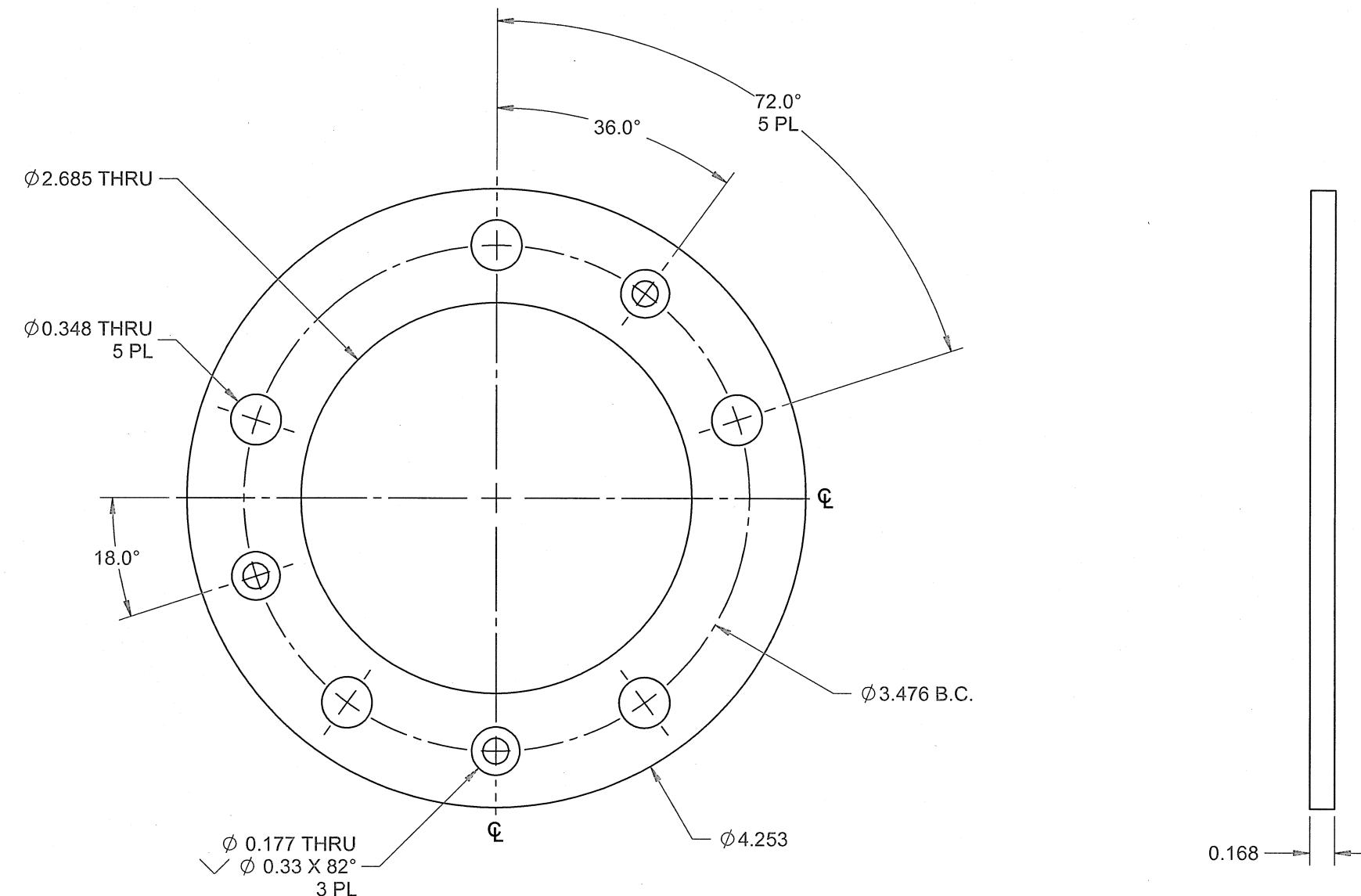
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RBW6510G04631-6F-5 SPACER

NOTES:

- 1) MATERIAL: NYLON 6
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: $X.X = +/- 0.1" / +/- 1^\circ$
 $X.XX = +/- 0.01" / +/- 0.5^\circ$
 $X.XXX = +/- 0.005" / +/- 0.1^\circ$
 $X.XXXX = +/- 0.0005" / +/- 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+/- 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD			
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA			
CHECKED	VM				
MFG. APPR.	FK				
APPROVED	WJ				
DATE	2019-07-09	REV. A			
TOOL PART #		RBW6510G04631-6F			
TITLE		SHEET 7 OF 10			
SCALE		NTS			
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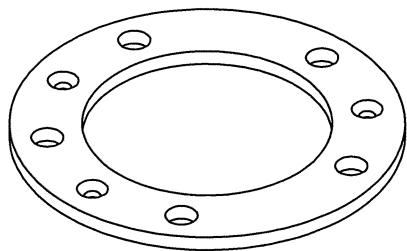
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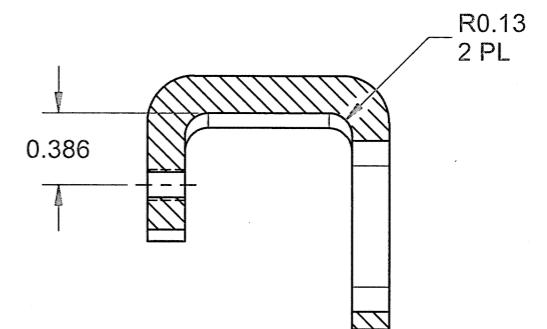
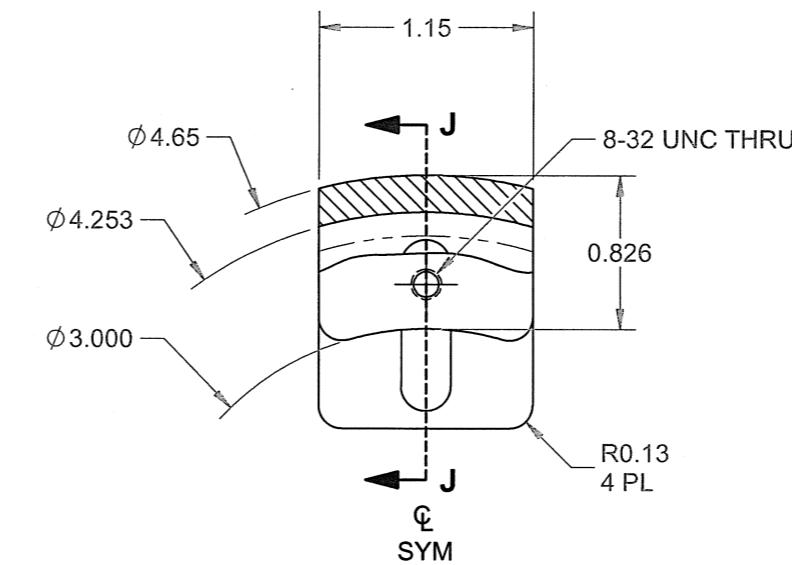
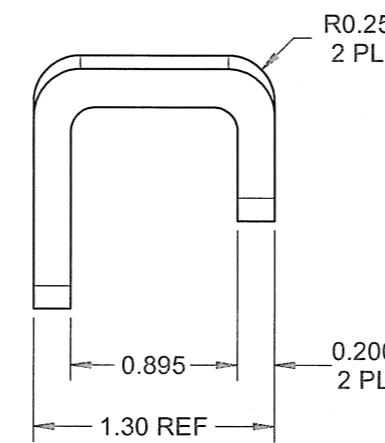
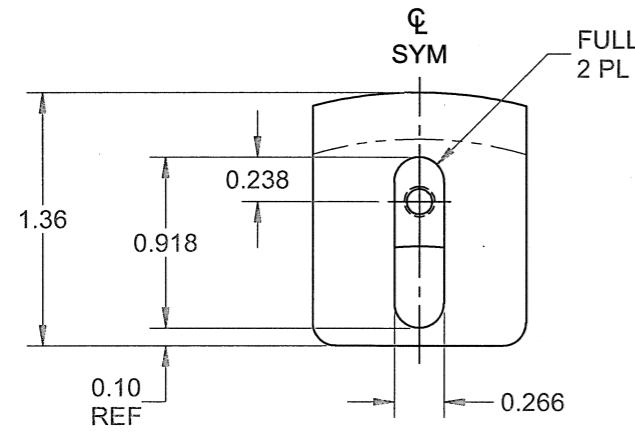
C

B

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A

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SECTION J-J

RBW6510G04631-6F-6 BRACKET

NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6510G04631-6F	SHEET 8 OF 10
APPROVED	VH	TITLE	SCALE
		REACTION ASSEMBLY	NTS
DATE 2019-07-09		COPRIGHT © 2019 BY DART AEROSPACE LTD	

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